



Ship Via:

https://www.plexonline.com/55ffb661-a491-451c-9bab-ae30ee5e5cb8/Plexus_Control/Report_View/Viewer_2.asp?URL=https://www.plexonline.com/55ffb66... 1/2

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	0.563Inches $\pm$ 0.010	0.573 0.553		
2	Strut	0.190Inches $\pm$ 0.010	0.200 0.180		
3	Strut	0.275Inches $\pm$ 0.010	0.285 0.265		
4	Strut	24.000Inches $\pm$ 0.030	24.030 23.970		
5	Strut	0.201Inches + 0.005 - 0.001	0.206 0.200		
6	Strut	45.0Angle $\pm$ 0.5	45.5 44.5		

Plex 3/1/18 9:54 AM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9910
Job Sheet 170548



Part No: 646.9910

Job Qty: 35 ea
29 ea

Part Name: Struts



Part Weight: 0 lbs

Job Created: 1/17/18

Due Date: 1/31/18

Type: SOLD

Ship Via:

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Mario Poulin

Description:

see attached mfg.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	35 Ea		1/30/18	0.00	0.00	Start Up Machining-1		
110	Doosan	35 pcs		1/31/18	0.00	6.88	Doosan		
120	QC	35 pcs		1/31/18	0.00	0.00	QC2 Machining-1		
170	QC	35 pcs		1/31/18	0.00	0.00	QC8 Machining-1		18-01-29
180	Outsource	35 pcs		1/31/18			ATG001-VC		
190	Packaging	35 pcs		1/31/18	0.00	0.00	Packaging2		
200	QC	35 pcs		1/31/18	0.00	0.00	QC5		
210	Packaging	35 pcs		1/31/18	0.00	0.00	Packaging3-1		
220	QC21-SA	35 Ea		1/31/18	0.00	0.00	QC21		

Part Op 110 - *** CUT BLANK ON CHOP SAW AT 24.030" LONG*** TURN AS PER DWG DWG REV: N/C FOLIO
Descriptions: REV: AA DEBURR

180 - Issue P/O to ATG: 038921 Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C

190 - Ensure certificate of conformity is attached

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

JAN 31 12:13

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.563	6061-T6 Round Bar .563	73.5000 ft (2.1 ea)	90-Start up Operation	

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut 0.565	0.563Inches ± 0.010	0.573 0.553		
2	Strut 0.190	0.190Inches ± 0.010	0.200 0.180		
3	Strut 0.275	0.275Inches ± 0.010	0.285 0.265		
4	Strut 24.00	24.000Inches ± 0.030	24.030 23.970		
5	Strut 0.201	0.201Inches + 0.005 - 0.001	0.206 0.200		
6	Strut 45	45.0Angle ± 0.5	45.5 44.5		

Nol

DART
AEROSPACE
S036048

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com



Struts

PART NO: 646.9910

Original Serial #: S036048

Revision:

Operation: Start up Operation 01/26/18

Change No:

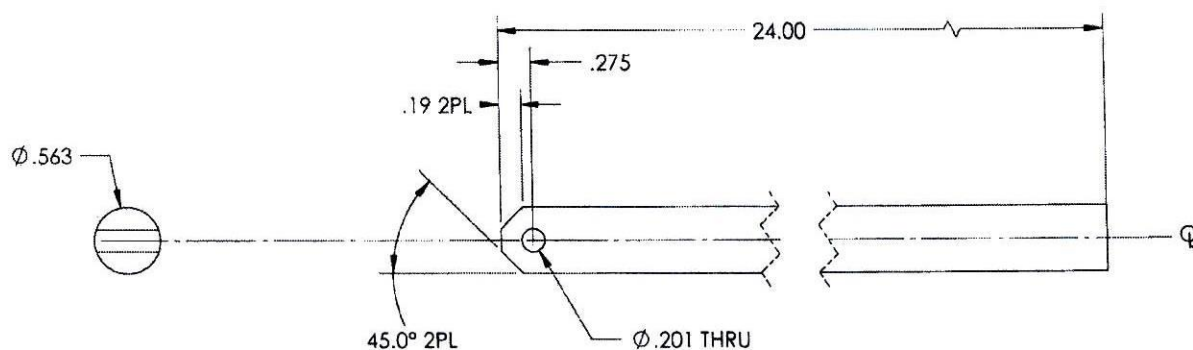
Job No: 170548

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REV	DESCRIPTION	DATE	APPROVED
1	LAST PRODUCTION PERIOD (PBT)		ISC
2	REPAIR RELEASE	04/21/00	P. BRAYO

NOTES:

- 1 MATERIAL: 6061-T6 ALUMINUM BAR IAW AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



646.9910

646.9910	STRUT			
PART #	DESCRIPTION	MAT'L	SPEC.	
QTY	DESCRIPTION			
NEXT ASSY (S)	646.9500			
DATE	04/21/00			
DRAWN BY	ISC			
CHECKED BY	P. BRAYO			
APPROVED BY				
DATE	04/21/00			
UNLESS OTHERWISE SPECIFIED				
DIMENSIONS ARE IN INCHES				
TOLERANCES ARE				
FRACTIONS DECIMALS				
DECIMALS				
ANGLES				
SCALE	NONE			
SHEET	1 OF 1			

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA 92056-3512 (760)724-5300

STRUT

QTY	646.9900	REV	07M26	DATE	04/21/00	BY	ISC
SCALE	NONE	SHEET	1 OF 1				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038921

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
16	168945	RBH9928-12-5	Water sealant -Certificate of Conformity is required Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	1 pcs	0 pcs	1 pcs	\$7.30/pcs	\$7.30
17	170102	RB T102103-3	Adapter -Issue P/O to ATG : ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	2/9/18	20 pcs	0 pcs	20 pcs	\$3.47/pcs	\$69.40
18	170336	RBT112800-3	PTO Seal Install Tool -Issue P/O to ATG : ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	2/9/18	6 pcs	0 pcs	6 pcs	\$3.47/pcs	\$20.82
19	170362	RBW109-3101-58-1-7	Handle -Issue P/O to ATG : ANODIZE COLOR BLUE, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	6 pcs	0 pcs	6 pcs	\$13.62/pcs	\$81.72
20	170378	RBW109-3101-58-2-3	Hammer Head -Issue P/O to ATG : ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	9 pcs	0 pcs	9 pcs	\$3.47/pcs	\$31.23
21	170475	646 3810	Bracket Issue P/O to ATG : Hard Anodize Black and Prime as per Dwg 646 3800	Firmed	2/9/18	24 pcs	0 pcs	24 pcs	\$7.67/pcs	\$184.08
22	170478	646 3813	AS350 Strut Bracket Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646 3800	Firmed	2/9/18	16 pcs	0 pcs	16 pcs	\$7.22/pcs	\$115.52
23	170545	RBW109-3101-58-1-7	Handle -Issue P/O to ATG : ANODIZE COLOR BLUE, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	6 pcs	0 pcs	6 pcs	\$13.62/pcs	\$81.72
24	170548	646 9910	Struts Issue P/O to ATG :	Firmed	2/16/17	29 pcs	0 pcs	29 pcs	\$14.52/pcs	\$421.08



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914688

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
24 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22461		Rev: N/C PO: PO038921 Line: 1
1 ea	Part: D4970-3 Windshield Deflector - Upper Hard Anodize, IAW MIL-A-8625 Type III Class 2, Color Black Job: 22462		Rev: C PO: PO038921 Line: 2
24 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22481		Rev: NC PO: PO038921 Line: 21
16 ea	Part: 646.3813 AS350 Strut Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22482		Rev: NC PO: PO038921 Line: 22
16 ea	Part: 646.9910 Struts Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22484		Rev: NC PO: PO038921 Line: 24
Made in Canada.			